












Date: Monday, 11/13/2006 12:10:48 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LITTER ASSEMBLY
Job Number	: 29434		
Estimate Number	: 10301		
P.O. Number	: <i>N/A</i>	Part Number	: D2370
This Issue	: 11/13/2006	Drawing Number	: D2370
S.O. No.	: <i>N/A</i>	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: B1
First Issue	: <i>N/A</i>	Material	: <i>N/A</i>
Type	: PURCHASED PARTS	Due Date	: 11/20/2006
Previous Run	: 29126	Qty:	2 Um: Each
Written By	: <i>[Signature]</i>		
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est D 01.10.10 Changed D2484 nut for D3015-1 SM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
			
Comment: PURCHASING Issue p/o: <i>2477</i> <i>CLae11113</i> (2) Order: Model 12-2A undrilled with grey pad & black belts Supplier: Ferno Aviation Letter of compliance required			
2.0	D2370P	Litter Assembly	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Litter Assembly			
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Receive and inspect for transit damage Insure that letter of compliance is attached to w/o <i>PL 8/14/14</i>			
4.0	QC6	DIMENSIONAL CHECK	
			
Comment: DIMENSIONAL CHECK <i>26.11.15</i> (2)			
5.0	D2374	Stud	
			
Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s) Stud Pick: Qty Part Number Description Batch 4 D2374 Stud <i>264594</i> <i>291374</i>			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/13/2006 12:10:48 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER ASSEMBLY

Job Number: 29434

Part Number: D2370

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2378

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

4

D2378

Mounting Bolt

B29444

X8

7.0

D30151

Lock Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lock Nut

Pick:

Qty

Part Number

Description

Batch

4

D3015-1

Lock Nut

B14710

X8

8.0

AN960JD416L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

4

AN960JD416L

Washer

M101237

X8

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2370

2-Drill 0.191" holes as per Dwg D2370

3-Deburr

06-11-17

ml

FF

①

①

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-11-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/11/15	90						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/15	90	2 rivets are not able to be easily removed. R.C. Poor manufacturing in the specific area. Rivet was installed into a solid piece of round bar, causing the rivet stem to break and not crimp.	AB 06/11/15	See PAR 187, engineering will redo the drawing and replace the 2 problem rivets with screws.	FF 06-11-09	06/11/20	AB 06/11/15	
11	11		AB 06/11/15	Remove the 2 rivets and tap the holes using a 1/4"-28 tap. Install 2x ms27039-4-06 m 15194 to replace the rivets.	ml FF 06/11/15	06/11/20	AB 06/11/15	

NOTE: Date & initial all entries

Date: Monday, 11/13/2006 12:10:48 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER ASSEMBLY

Job Number: 29434

Part Number: D2370

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11/14/20

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/22

Job Completion



U 06.11.21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

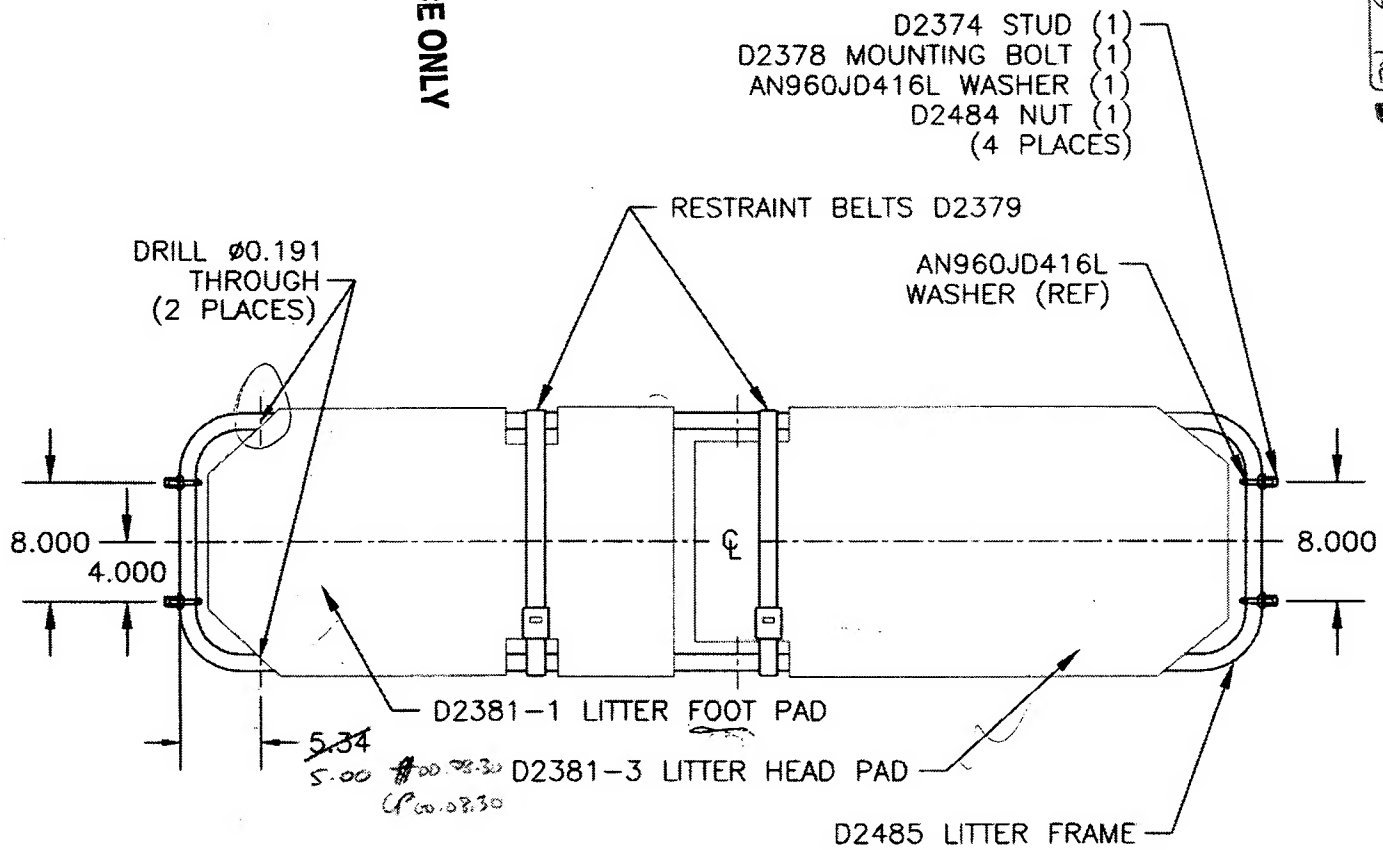
NOTE: Date & initial all entries

QA COPY ISSUED TO

RELEASED
44/60915 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURT, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2370	SHEET 2 OF 2
DATE		TITLE	SCALE
98.06.09		LITTER ASSEMBLY	1:12

REFERENCE ONLY





DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2370	REV. B SHEET 1 OF 2
DATE 98.06.09		TITLE LITTER ASSEMBLY	SCALE NTS
A	95.02.20	NEW ISSUE	
B	98.06.09	ADDED Ø0.191 HOLES	
B1	01-10-10	ADD ALTERNATE FOR D2484	

RELEASED
98/06/15 KE

CP

D2370	Part No.	Description
X	D2370	LITTER ASSEMBLY
1	D2485	LITTER FRAME
2	D2379	RESTRAINT BELTS
4	D2374	STUD
4	D2378	MOUNTING BOLT
1	D2381-1	LITTER PAD
1	D2381-3	LITTER PAD
4	D2484	NUT (<i>OR D3015-1</i>)
4	AN960JD416L	WASHER

REFERENCE ONLY

RNO Aviation, INC.

35-B Branch Drive
Alpharetta, GA 30004
Office 770.521.1005 Fax 770.521.0910
<http://aviation.ferno.com>

Commercial Invoice

DATE	INVOICE NO.
11/13/2006	6324

BILL TO
Dart Aerospace, Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Canada Attn: Accounts Payable

SHIP TO
Dart Aerospace, Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Canada Ref: PO 00002477

PO NO.	TERMS	REP	SHIP DATE	SHIP VIA	FOB
00002477 ✓	Net 30	DN	11/13/2006	Federal Express	Alpharetta,GA
ITEM	DESCRIPTION	QTY	UNIT PRICE	AMOUNT	
12-2A (DART)	12-2A Litter Assembly W/Gray FAA Approved cover/pad assy. and Black FAA approved patient restraints S/N: 06-012086, 06-012088 (HS Code 8803.30.00.00)	2 ✓	1,268.00	2,536.00	
Shipping	Shipped on account # 1517-9324-0 Tracking # 856338267929		0.00	0.00	
Thank you for your order!				Total \$2,536.00	



70 Weil Way ! Wilmington, OH 45177-9371 ! (937) 382-1451 ! FAX (937) 382-1191

Int'l FAX (937) 382-6569

Visit us at our web site: www.ferno.com

23 May, 2006

Certificate of Conformance

Manufacturer: Ferno-Washington, Inc.

Manufacturer's Address: 70 Weil Way
Wilmington, OH 45177-9371
USA

Order No. C-781812

Reference P.O. 3775

Ferno Model No 12-2 Stretcher

Ferno Serial No. 06-012088; 06-012091; 06-012089; 06-012090;
06-012087; 06-012085; 06-012086

I certify that the above referenced products were produced in accordance with applicable Ferno-Washington engineering standards using approved manufacturing methods and materials. The products have been inspected using approved test procedures and inspection criteria for Ferno-Washington medical devices. Ferno-Washington has a Quality Assurance system.

Dorothy Deaton

Dorothy Deaton
Regulatory Affairs

Certificate of Analysis



Client:		Foam Type:	11032 CFR
Ohio Foam Corporation		Lot Number:	71805
1511 South Alum Creek			Blue
Columbus, Ohio 43208			
Fax: 614-252-1213			

Test	Methods	Frequency	Requirements	Results
Density (lbs per cubic ft.)	ASTM D3574-03 Test A	Daily	1.05 - 1.15	1.09
IFD (4" 25% lbw/50 sq in.)	ASTM D3574-03 B1	Daily	28 - 38	28.81
Tensile Strength (As rec'd psi) min	ASTM D3574-03 Test E	Monthly	12.0	13.94
Tear Strength (lbs per inch) min	ASTM D3574-03 Test F	Monthly	1.2	1.88
Elongation (% min)	ASTM D3574-03 Test E	Monthly	120%	210%
Flammability	CAL Burn Test (TIB 117)	Daily	PASS	PASS
	MVSS302	Daily	PASS	PASS
Air Flow (1" Thick) min	Q1-104	Daily	3.5	3.56

Authorized Signature

Date

8-20-05

FLEXIBLE FOAM PRODUCTS, INC.

200 East North St, P.O. Box 124
 Spencerville, OH 43087
 Ph. (419) 647-4172 Fax (419) 647-6720

Certificate of Analysis



Client: Ohio Foam Corporation
1511 South Alum Creek
Columbus, Ohio 43209
Fax: 814-252-1213

Foam Type: 11032 CFR
Lot Number: 71805
Blue

Test	Method	Frequency	Requirements	Results
Density (lbs per cubic ft.)	ASTM D3574-03 Test A	Daily	1.05 - 1.15	1.09
IFD (4" 25% lb/50 sq in.)	ASTM D3574-03 B1	Daily	28 - 38	29.81
Tensile Strength (As rec'd psi) min	ASTM D3574-03 Test E	Monthly	12.0	13.94
Tear Strength (lbs per inch) min	ASTM D3574-03 Test F	Monthly	1.2	1.88
Elongation (% min)	ASTM D3574-03 Test E	Monthly	120%	210%
Flammability	CAL Burn Test (TIB 117)	Daily	PASS	PASS
	MVSS302	Daily	PASS	PASS
Air Flow (1" Thick) min	Q1-104	Daily	3.5	3.56

Authorized Signature

Date:

8-22-05

FLEXIBLE FOAM PRODUCTS, INC.

200 East North St., P.O. Box 124
Spencerville, OH 43087
Ph. (419) 647-4172 Fax (419) 647-6720



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Int'l FAX (937) 382-6100
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23 May, 2006

Certificate of Conformance

Manufacturer: Ferno-Washington, Inc.
Manufacturer's Address: 70 Weil Way
Wilmington, OH 45177-9371
USA
Order No. C-781812
Reference P.O. 3775
Ferno Model No 12-2 Stretcher
Ferno Serial No. 06-012088; 06-012091; 06-012089; 06-012090;
06-012087; 06-012085; 06-012086

I certify that the above referenced products were produced in accordance with applicable Ferno-Washington engineering standards using approved manufacturing methods and materials. The products have been inspected using approved test procedures and inspection criteria for Ferno-Washington medical devices. Ferno-Washington has a Quality Assurance system.

Dorothy Deaton

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Regulatory Affairs